

Date: Thursday, 3/2/2006 3:07:07 PM
 User: Kim Johnston

Process Sheet

12

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: VERTICAL REFERENCE DOOR 212/412		
Job Number	: 26023		Part Number	: D412711011		
Estimate Number	: 10887		Drawing Number	: N/A		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 3/2/2006 S.O. No. : N/A		Drawing Revision	: N/A		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 3/20/2006 Qty: 1 Um: Each		
Previous Run	: 21900					
Written By	: See COMMENT Below					
Checked & Approved By	: KJ 06.03.02					
Comment	: Est Rev:A 04.09.29 New issue KJ/JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
2.0	PACKAGING 1	PACKAGING RESOURCE #1 <i>(Signature over barcode)</i> <i>DA 06-02-06</i> <i>06-03-02</i> <i>?</i>
3.0	D412711041	Vertical Ref. Door Assy
4.0	D412711111	Wiring Harness, 212/412
5.0	EA2046915412	Instrument Panel, 412

Comments and Handwritten Notes:

- Line 1:** Comment: DOCUMENT CONTROL
Photocopy bluefiles and create labels per PPP D412-711-011 CHG001
- Line 2:** Comment: PACKAGING RESOURCE #1
Pick Packing Kit
- Line 3:** Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch 1 D412-711-041 Vertical Reference Door 25672 from S-26
- Line 4:** Comment: Qty.: 1.0000 Eagle(s)/Unit Total : 1.0000 Eagle(s)
Pick: Packing Kit
Qty Part Number Description Batch 1 D412-711-111 Wiring Harness, 212/412 B21901
- Line 5:** Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch 1 EA20469-15-412 Instrument Panel, 212/412 M19150 C 20103/15 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/03/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/2/2006 3:07:07 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR 212/412

Job Number: 26023

Part Number: D412711011

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC4

INSPECT 100% KITS FOR COMPLETENESS



U 06-03-15



Comment: INSPECT 100% KITS FOR COMPLETENESS

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-711-011

Location:

PPP Rev:

C 06/03/15 81

8.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/03/15

Job Completion



U 06-03-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Dart Aerospace Ltd.

Date: Friday, 23/03/2006 2:30:29 PM
User: Linda Leslie

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	: VERTICAL REFERENCE DOOR ASSEMBLY		
Job Number	25672		Part Number	: D412711041		
Estimate Number	10902		Drawing Number	: N/A		
P.O. Number	:		Project Number	: N/A		
This Issue	2/3/2006	S.O. No. :	Drawing Revision	: N/A		
Prsh Rev.	NC		Material	: N/A		
First Issue	1/30/2006	Type : PURCHASED PARTS	Due Date	: 3/15/2006 Qty: 1 Um: Each		
Previous Run	25671					
Written By	:					
Checked & Approved By	:					
Comment	: Est Rev/A 04.08.18 New Issue KJ/DS					
Additional Product						
Job Number: 						
Seq. #:	Machine Or Operation:	Description :				
1.0 PG		PURCHASING 				
Comments: PURCHASING 496 Issue P/O: 496 to Eagle Copters "Assembly of D412-711-041 Door Assembly in accordance with Dart IPP D412-711-041" Send a copy of this IPP						
2.0 OUTSIDE SERVICE		OUTSIDE SERVICES 				
Comment: Sub-Contracting OUTSIDE SERVICES						
EAGLE						
Pick.Qty Part Number Description Batch						
1 204-030-853-119 LH Co-pilot Door <u>1/042375</u>						
Attach serviceable tags						
2- EAGLE						
Fabricate/Pick the following parts to go into the door in accordance with:						
1 Rev. 3						
D2046902 Sheet 2 Rev. 2						
D2046902 Sheet 3 Rev. 0						
D2046901 Sheet 3 Rev. 1						
Qty	Part Number	Description	Batch			
1	EB212-100L/EA20468-3	Window	<u>1/042375</u>			
1	EA20469-05	Rubber Strip	<u>1/042375</u>			
1	EA20469-06	Aluminum Strip	<u>1/042375</u>			
1	EA20469-07	Angle	<u>1/042375</u>			
1	EA20469-08	Placard	<u>1/042375</u>			
1	EA20469-10	Rear Rib Assy	<u>1/042375</u>			
1	EA20469-11	Angle	<u>1/042375</u>			

03/14/2006 TUE 15:45 FAX 403 250 7110 Eagle Copters PH250 7370

4003/004

02/02/2006 16:03 6136321053

DART AEROS

PAGE

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Date: Friday, 2/3/2006 2:30:30 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR ASSEMBLY

Job Number: 25672

Part Number: D412711041

Job Number:



Seq. #:

Machine Or Operation:

Description :

1	EA20469-12	Fwd Rib	<i>W/0 40359</i>
1	EA20469-13	Window	<i>W/0 40359</i>
1	EA20469-14	Window Retainer	<i>W/0 40359</i>
1	EA20469-16	Armrest Assy	<i>W/0 40359</i>
1	EA20469-17	Angle	<i>W/0 40359</i>
1	EA20469-18	Door Inner Skin	<i>W/0 40359</i>
1	EA20469-21	Door Cover Panel	<i>W/0 40359</i>
2	EA20469-23	Link	<i>W/0 40359</i>
1	EA20469-24	Rod	<i>W/0 40359</i>
1	EA20469-25	Arm Assy	<i>W/0 42444</i>

Material Certification / Proof of Traceability / Certificate of Conformity required

3-EAGLE

Pick:

Qty Part Number Description Batch

14 AN3-3ABolt *AT-01-5678*
22 AN3-4ABolt *AT-01-5678*
24 AN3-7ABolt *AT-01-3201*
5 AN960-8L Washer *AT-01-3201*

90 AN960-10L Washer

34 CR3242-4-2 Rivet *AT-01-444*
135MS20426AD3-3 Rivet *AT-05-00344*
140MS20426AD4-3 Rivet *AT-05-00344*
25 MS20470AD3-3 Rivet *AT-05-00344*
90 MS20470AD4-3 Rivet *AT-05-00344*
24 MS21042L3 Nut *AT-05-022104*
2 MS21042L06 Nut *AT-05-022104*
13 MS21069L3 Nut Plate *AT-05-022838*
8 MS21069L08 Nut Plate *AT-05-004793*
1 MS21071L3 Nut Plate *AT-05-024463*
1 MS21071L08 Nut Plate *AT-05-024477*
9 MS21075L3 Nut Plate *AT-05-013450*
2 MS24877-12 Screw *AT-05-011931*
6 MS27039-1-09 Screw *AT-05-016760*

4-Assemble door in accordance with : D2046901 Sheet 2 Rev. 5 D2046901 Sheet 1 Rev. 5 Do not install
EA20469-15 or wiring harness at this time.

5-Apply Dart P/N & B/N using fine point permanent marker

Date: Friday, 2/3/2008 2:30:30 PM
 User: Linda Lacalle

Process Sheet

Drawing Name: VERTICAL REFERENCE DOOR ASSEMBLY

Customer: CL-DAR001 Dart Helicopters Services

Job Number: 25672

Part Number: D412711041

Job Number:



Seq. #: Machine Or Operation:

Description:

3.0 QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: Eagle- INSPECT 100% KITS FOR COMPLETENESS

Send this W/O back to DartKit to be stocked at Eagle

4.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

5.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



F A X

Date: MARCH 14/04

Number of pages including cover sheet:

To:

LINDA

Tel:

Fax:

CC:



Toll-Free: 1-800-564-6469

Tel: (403) 250-7370, Fax: (403) 250-7110

Eagle Copters Maintenance Ltd.

823 McTavish Road NE

Calgary, Alberta, Canada T2B 7G9

REMARKS:

Urgent

For your review

Reply ASAP

Please comment

*This is the door being shipped to
ACCENT*

JASON

Date: Monday, 1/30/2006 3:43:57 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: VERTICAL REFFERENCE DOOR ASSEMBLY		
Job Number	: 25672			Part Number	: D412711041		
Estimate Number	: 10902			Drawing Number	: N/A		
P.O. Number	:			Project Number	: N/A		
This Issue	: 1/30/2006	S.O. No.	:	Drawing Revision	: N/A		
Prsht Rev.	: NC			Material	: N/A		
First Issue	: / /	Type	: PURCHASED PARTS	Due Date	: 3/15/2006	Qty:	1
Previous Run	: 25671			Um:	Each		
Written By	:						
Checked & Approved By	: <i>dk</i> 06.01.30						
Comment	: Est Rev:A 04.08.18 New Issue KJ/DS						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 497 to Eagle Copters*11 06-02-01*

1

"Assembly of D412-711-041 Door Assembly in accordance with Dart IPP D412-711-041"

Send a copy of this IPP

2.0	OUTSIDE SERVICE	OUTSIDE SERVICES
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Comment: Sub-Contracting OUTSIDE SERVICES

EAGLE

Pick:Qty Part Number Description Batch

1 204-030-853-119 LH Co-pilot Door _____

Attach serviceable tags

2- EAGLE

Fabricate/Pick the following parts to go into the door in accordance with:

D2046902 Sheet

1 Rev. 3

D2046902 Sheet 2 Rev. 2

D2046902 Sheet 3 Rev. 0

D2046901 Sheet 3 Rev. 1

Qty	Part Number	Description	Batch
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1	EB212-100L / EA20469-3	Window	_____
1	EA20469-05	Rubber Strip	_____
1	EA20469-06	Aluminum Strip	_____
1	EA20469-07	Angle	_____
1	EA20469-08	Placard	_____
1	EA20469-10	Rear Rib Assy	_____
1	EA20469-11	Angle	_____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFFERENCE DOOR ASSEMBLY

Job Number: 25672

Part Number: D412711041

Job Number:



Seq. #:	Machine Or Operation:	Description :
1	EA20469-12	Fwd Rib _____
1	EA20469-13	Window _____
1	EA20469-14	Window Retainer _____
1	EA20469-16	Armrest Assy _____
1	EA20469-17	Angle _____
1	EA20469-18	Door Inner Skin _____
1	EA20469-21	Door Cover Panel _____
2	EA20469-23	Link _____
1	EA20469-24	Rod _____
1	EA20469-25	Arm Assy _____

Material Certification / Proof of Traceability / Certificate of Conformity required

3-EAGLE

Pick:

Qty	Part Number	Description	Batch
14	AN3-3ABolt		
22	AN3-4ABolt		
24	AN3-7ABolt		
6	AN960-6L	Washer	
90	AN960-10L	Washer	
34	CR3242-4-2	Rivet	
135	MS20426AD3-3	Rivet	
140	MS20426AD4-3	Rivet	
25	MS20470AD3-3	Rivet	
90	MS20470AD4-3	Rivet	
24	MS21042L3	Nut	
2	MS21042L06	Nut	
13	MS21069L3	Nut Plate	
8	MS21069L08	Nut Plate	
1	MS21071L3	Nut Plate	
1	MS21071L08	Nut Plate	
9	MS21075L3	Nut Plate	
2	MS24677-12	Screw	
6	MS27039-1-09	Screw	

4-Assemble door in accordance with : D2046901 Sheet 2 Rev. 5 D2046901 Sheet 1 Rev. 5Do not install EA20469-15 or wiring harness at this time.

5-Apply Dart P/N & B/N using fine point permanent marker

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/30/2006 3:43:58 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFFERENCE DOOR ASSEMBLY

Job Number: 25672

Part Number: D412711041

Job Number:



Seq. #:	Machine Or Operation:	Description :
3.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
Comment: Eagle- INSPECT 100% KITS FOR COMPLETENESS Send this W/O back to DartKit to be stocked at Eagle		
4.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____		
5.0	DC	DOCUMENT CONTROL
Comment: DOCUMENT CONTROL Inspection Level 21		

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Dart Aerospace Ltd.

Date: Friday, 2/3/2006 2:30:29 PM
 User: Linda Lecelle

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	VERTICAL REFERENCE DOOR ASSEMBLY
Job Number	25672	Part Number	D412711041
Estimate Number	10902	Drawing Number	N/A
P.O. Number	:	Project Number	N/A
This Issue	2/3/2006	S.O. No.	:
Prsh Rev.	NC	Drawing Revision	N/A
First Issue	1/30/2006	Type	PURCHASED PARTS
Previous Run	25671	Material	N/A
Written By	:	Due Date	3/15/2006
Checked & Approved By	:	Qty:	1
Comment	Est Rev:A 04.08.18 New Issue KJ/DS	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	PG	PURCHASING

Comment: PURCHASING 496
 Issue P/O: 496 to Eagle Copters
 "Assembly of D412-711-041 Door Assembly in accordance with Dart IPP D412-711-041"
 Send a copy of this IPP

2.0	OUTSIDE SERVICE	OUTSIDE SERVICES

Comment: Sub-Contracting OUTSIDE SERVICES

EAGLE

Pick Qty Part Number Description Batch
 1 204-030-853-119 LH Co-pilot Door W/40375
 Attach serviceable tags

2- EAGLE

Fabricate/Pick the following parts to go into the door in accordance with:

D2046902 Sheet

1 Rev. 3

D2046902 Sheet 2 Rev. 2

D2046902 Sheet 3 Rev. 0

D2046901 Sheet 3 Rev. 1

Qty	Part Number	Description	Batch
1	EB212-100L / EA20469-3	Window	<u>W/42375</u>
1	EA20469-05	Rubber Strip	<u>W/42375</u>
1	EA20469-06	Aluminum Strip	<u>W/40359</u>
1	EA20469-07	Angle	<u>W/40359</u>
1	EA20469-08	Placard	<u>W/40359</u>
1	EA20469-10	Rear Rib Assy	<u>W/40359</u>
1	EA20469-11	Angle	<u>W/40359</u>

Date: Friday, 2/3/2006 2:30:30 PM
 User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR ASSEMBLY

Job Number: 25672

Part Number: D412711041

Job Number:



Seq. #:	Machine Or Operation:	Description :
1	EA20469-12	Fwd Rib <i>W/0 40359</i>
1	EA20469-13	Window <i>W/0 40359</i>
1	EA20469-14	Window Retainer <i>W/0 40359</i>
1	EA20469-16	Armrest Assy <i>W/0 40359</i>
1	EA20469-17	Angle <i>W/0 40359</i>
1	EA20469-18	Door Inner Skin <i>W/0 40359</i>
1	EA20469-21	Door Cover Panel <i>W/0 40359</i>
2	EA20469-23	Link <i>W/0 40359</i>
1	EA20469-24	Rod <i>W/0 40359</i>
1	EA20469-25	Arm Assy <i>W/0 42444</i>

Material Certification / Proof of Traceability / Certificate of Conformity required

3-EAGLE

Pick:

Qty	Part Number	Description	Batch
14	AN3-3ABolt	Rivet	LT-01-5698
22	AN3-4ABolt	Rivet	LT-05-022652
24	AN3-7ABolt	Rivet	LT-05-022659
6	AN960-6L	Washer	LT-01-3051
90	AN960-10L	Washer	
34	CR3242-4-2	Rivet	LT-05-017444
136	MS20426AD3-3	Rivet	LT-05-002460
140	MS20426AD4-3	Rivet	53852
25	MS20470AD3-3	Rivet	LT-05-022472
90	MS20470AD4-3	Rivet	LT-05-022440
24	MS21042L3	Nut	LT-05-022644
2	MS21042L06	Nut	LT-05-022704
13	MS21069L3	Nut Plate	LT-05-022828
8	MS21069L08	Nut Plate	LT-05-024730
1	MS21071L3	Nut Plate	LT-05-024463
1	MS21071L08	Nut Plate	LT-05-024479
9	MS21075L3	Nut Plate	LT-05-013470
2	MS24677-12	Screw	LT-05-011931
6	MS27039-1-09	Screw	LT-05-016760

4-Assemble door in accordance with : D2046901 Sheet 2 Rev. 5 D2046901 Sheet 1 Rev. 5 Do not install EA20469-15 or wiring harness at this time.

5-Apply Dart P/N & B/N using fine point permanent marker

Date: Friday, 2/3/2006 2:30:30 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR ASSEMBLY

Job Number: 25672

Part Number: D412711041

Job Number:



Seq. #:	Machine Or Operation:	Description :
3.0	QC4	INSPECT 100% KITS FOR COMPLETENESS 
4.0	PACKAGING 1	PACKAGING RESOURCE #1
5.0	DC	DOCUMENT CONTROL

Job Completion

